

Work Order ID 60934

July 27, 2010 11:36:22 AM



Page 1

Item ID: D5953

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, 205

Start Date: 7/27/10

Start Qty: 4.00



Cust Item ID:

Required Date: 8/06/10

Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5953

Rev B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio D5953, Ensure Batch Number is entered ☐ 2-Machine
Keyway ☐ 3-Deburr & Tumble

DTT
10/08/03

5

0

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

SA 10/08/03

5

0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SA 10/08/10

5

0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 08 10 5

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:00pm FINISH TIME: 2:30pm OVEN TEMPERATURE: 320°F

10/08/10

5 9

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/8/10 SP 50

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Required Date: 8/06/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location <u>430</u>	0.00							
Packaging Packaging	Memo	0.00				10/8/10	SP	SP	
170 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/08/11 *[Signature]*

MF
10-8-11

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Picklist Print

July 27, 2010 11:36:19 AM

Page 1

Work Order ID: 60934

Parent Item: D5953

Parent Item Name: Saddle, 205

Start Date: 7/27/10

Required Date: 8/06/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:f ecn 826 06.12.06 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007

Manufactured

No

100

Each

60.0000

1

4



Saddle Billet



Location

Loc Qty

Loc Code

MAT

14

59621

14

MAT42

46

46412

2

58677

4

60314

40

5 DFP 10/08/03

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DART AEROSPACE LTD		Work Order: 60934
Description: Inner Fwd Saddle		Part Number: D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	
A	0.438	0.443		0.441	0.441	0.441	0.441	0.441
B	1.745	1.755		1.750	1.750	1.750	1.750	1.750
C	5.245	5.255		5.250	5.250	5.250	5.250	5.250
D	6.995	7.005		7.000	7.000	7.000	7.000	7.000
E	5.240	5.260		5.250	5.250	5.250	5.250	5.250
F	4.745	4.755		4.750	4.750	4.750	4.750	4.750
G	0.315	0.322		0.317	0.321	0.321	0.321	0.321
H	1.522	1.532		1.527	1.527	1.527	1.527	1.527
I	3.048	3.058		3.053	3.053	3.053	3.053	3.053
J	4.575	4.585		4.580	4.580	4.580	4.580	4.580
K	0.315	0.322		0.317	0.321	0.321	0.321	0.321
L	0.495	0.505		0.500	0.500	0.500	0.500	0.500
M	0.490	0.510		0.503	0.504	0.505	0.504	0.504
N	1.615	1.635		1.625	1.625	1.625	1.625	1.625
O	7.990	8.010		7.998	7.999	7.999	7.999	7.999
P	2.240	2.260		2.250	2.250	2.250	2.250	2.250
Q	0.307	0.312		0.312	0.311	0.311	0.311	0.311
R	0.760	0.765		0.763	0.762	0.762	0.762	0.762
S	0.490	0.510		0.498	0.498	0.499	0.495	0.497
T	1.375	1.395		1.376	1.376	1.381	1.378	1.378
U	2.000	2.020		2.003	2.003	2.006	2.004	2.004
V								
W								
X								
Y								
Z								
AA								
AB								
AC								
AD								
AE								
AF								
Accept/Reject								

Measured by: DTJ
Date: 10/08/13

Audited by: SA
Date: 10/08/10

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	
F	08.12.01	Dimension K revised	KJ/DD	

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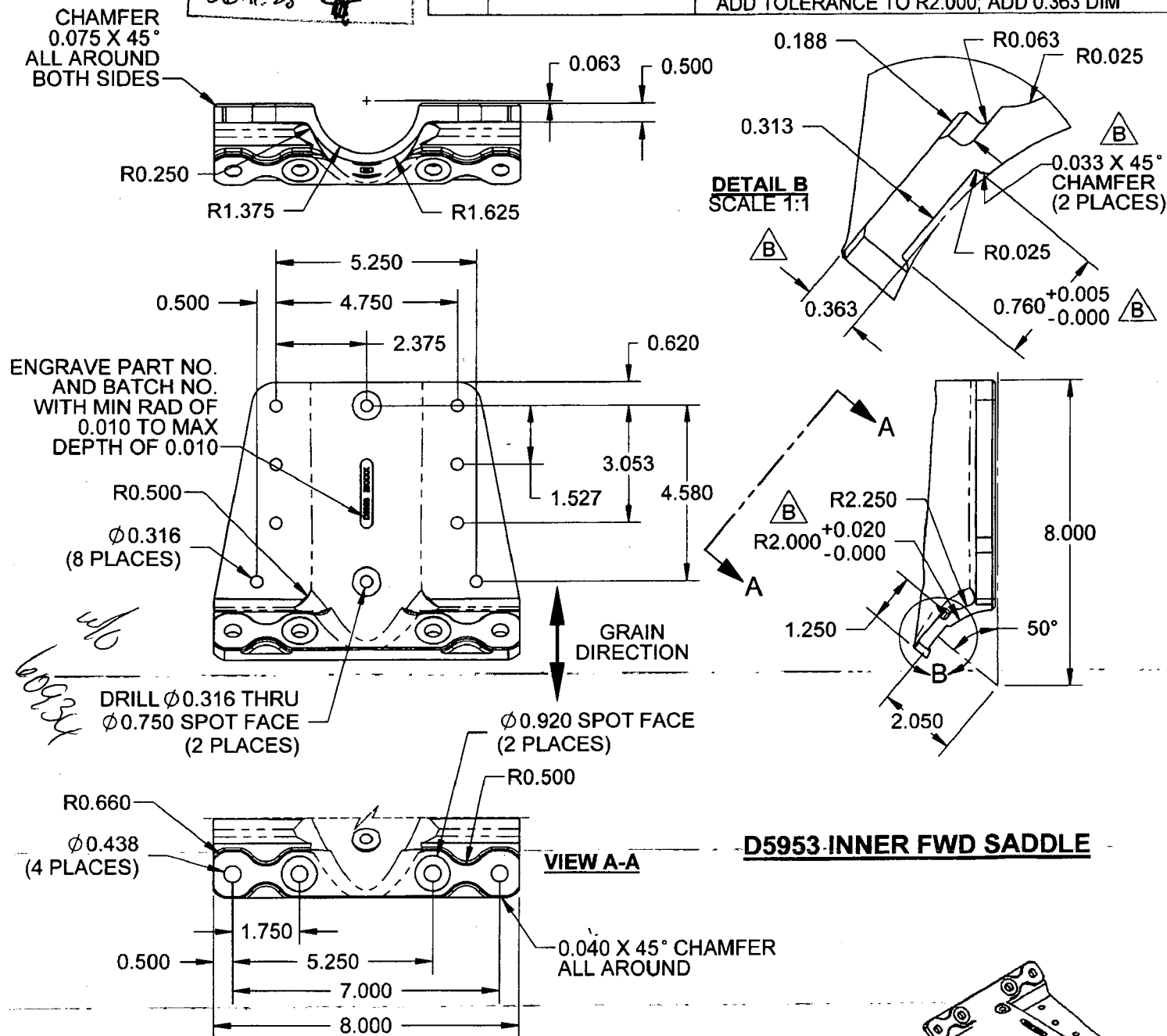
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DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5953	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER FWD SADDLE		SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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